

# Work Order ID 52702

October 8, 2009 10:20:04 AM

Page 1

Item ID: D212-725-1-143

Accept

Setup Start

Revision ID: D

Stop

Item Name: Base Plate

Start Date: 10/08/09 Start Qty: 10.00

Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: *CL*

Date: *09/10/08* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

D

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

FLOW WATER JET

1-Cut as per Dwg D212-725-1 p.47

Dwg Rev: *D*

Prog Rev: *D*

2-Deburr if necessary

*= 7 m. h 09/10/18*

*(14X)*

*(14)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*B 9-10-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52702

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Page 2

Item ID: D212-725-1-143

Accept



Setup Start



Revision ID: D

Stop



Item Name: Base Plate

Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	22809/10/17			(2/4)	/		
130  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00  0.00	367			2/10/19	54	(142)	S
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				09/10/20 MF 09-10-20			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October 8, 2009 10:20:04 AM

Work Order ID: 52702

Parent Item: D212-725-1-143

Parent Item Name: Base Plate

Comments:



Start Date: 10/08/09

Required Date: 10/21/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	114.1552	10.0000	14.00		



304/316 .050 Sheet

10/9-16

M304S226A

9/24/09 10:13

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

114.1552053

108156

0.98526316

111743

23.7174

112178

89.4525421

304 .032

109057

109057

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

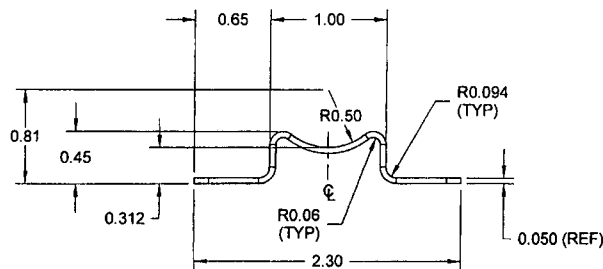
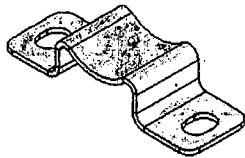
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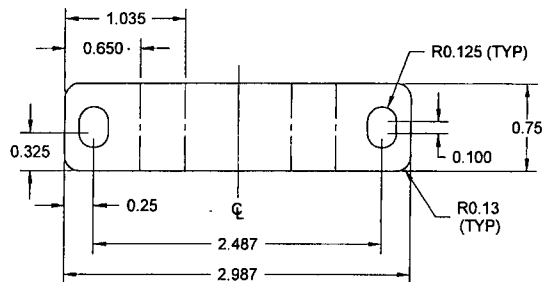


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WITHOUT NOTICE  
WORK ORDER  
NO. 52702  
209110108

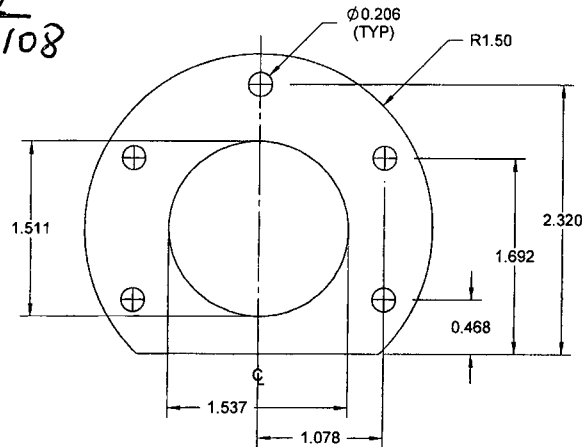


**D212-725-1-141 BRACKET**  
(MAKE FROM D212-725-1-141F)



**D212-725-1-141F FLAT PATTERN**

- D212-725-1-141 NOTES:**  
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 THICK (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: N/A



**D212-725-1-143 BASE PLATE**

- D212-725-1-143 NOTES:**  
1) MATERIAL: AISI 301/304 STAINLESS STEEL 1/4 HARD 0.032 THICK (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: N/A

RELEASED  
080703ML

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IDS	DRAWING NO. <b>D212-725-1</b>	REV. C
MFG. APPR.			SHEET 47 OF 49
APPROVED		TITLE <b>212S DETAIL PARTS</b>	SCALE 1:1
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.12.04		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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